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November 23, 1999

Assistant Commissioner for Patents  
Washington, DC 20231

Application for U.S. Letters Patent  
Docket No. ZW-24B

JCS30 U.S. PTO  
09/450037  
11/29/99

Sir:

- (1) This is a request for the filing of a Divisional Patent Application pursuant to CFR 1.60 for an invention disclosed in a prior-filed nonprovisional patent application, Serial No. 09/134,634, filed 8/14/98:  
Applicant(s): Richard Allen Venable, Kenneth Glenn Ezell  
David Eugene Hartley  
Title: "Planishing Apparatus and Method"
- (2) Enclosed herewith is a copy of the prior complete application as filed, including specification (with claims), drawings, and declaration showing signatures, together with a statement that such papers constitute a true copy of the prior complete application. No amendments have been filed in relation to the parent application. The inventors in the divisional application are the same as in the parent application.
- (3) Please amend the application by adding, preceding the heading "**Field of the Invention**", "This is a division of U.S. patent application serial no. 09/134,634, filed 8/14/98 by R.A. Venable, K.G. Ezell, and D.E. Hartley." and by canceling claims 5-7.
- (3) The Commissioner is hereby authorized to charge payment of the following fees during the pendency of this application or credit any overpayment to Deposit Account No. 13-1955. Two duplicate copies of this sheet are enclosed.
- |  |           |
|--|-----------|
| Basic Filing Fee .....   | \$ 760.00 |
| Additional Fees:   |           |
| Total number of claims, less 20 = <u>0</u> x \$22.00 = <u>0</u>      |           |
| Number of independent claims, less 3 = <u>0</u> x \$82.00 = <u>0</u> |           |
| Total Basic Filing Fee .....   | \$ 760.00 |
| Total Filing Fee \$ <u>760.00</u>                                    |           |

Respectfully,



William H. Meise  
Registration No. 27574  
(In triplicate)

/mjp  
Enclosures

**IN THE UNITED STATES PATENT AND TRADEMARK OFFICE**

Applicant(s): Richard Allen Venable et al.  
Title: *Planishing Apparatus and Method*  
Filed: Herewith


**TRUE COPY STATEMENT**

Assistant Commissioner for Patents  
Washington, DC 20231

Sir:

The undersigned, a registered patent attorney, hereby verifies that the accompanying specification (with claims), drawings, and Declaration showing signatures, are a true copy of the parent or prior complete application, serial number 09/134,634, filed 8/14/98.

Respectfully submitted,

BY:   
William H. Meise  
Registration No. 27,574

November 23, 1999  
Enclosures

Patent Operation  
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DECLARATION AND POWER OF ATTORNEY FOR PATENT APPLICATION

As a below named inventor, I hereby declare that:

My residence, post office address and citizenship are as stated below next to my name.

I believe I am an original, first and sole inventor (if only one name is listed below) or an original, first and joint (34) inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled:

"PLANISHING APPARATUS AND METHOD"

the specification of which

(check one) X is attached hereto.

\_\_\_\_\_ was filed on \_\_\_\_\_ as  
Application Serial No. \_\_\_\_\_  
and was amended on \_\_\_\_\_ (if  
applicable).

I hereby state that I have reviewed and understand the contents of the above identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose information which is material to the examination of this application in accordance with Title 37, Code of Federal Regulations, §1.56(a).

I hereby claim the benefit under Title 35, United States Code, §120 of any United States application(s) listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States application in the manner provided by the first paragraph of Title 35, United States Code, §112, I acknowledge the duty to disclose material information as defined in Title 37, Code of Federal Regulations, §1.56(a) which occurred between the filing date of the prior application and the national or PCT international filing date of this application:

Serial No. **60/083,398**

Filing Date **4/29/98**

Status **Pending**

I hereby appoint the following attorneys to prosecute this application and to transact all business in the United States Patent and Trademark Office connected therewith: William H. Meise, Registration No. 27,574, Geoffrey H. Krauss, Registration No. 27,343, Stephen A. Young, Registration No. 25,048, John J. Morrissey, Registration No. 26,208; Gay Chin, Registration No.

18,875; and Patrick M. Hogan, Registration No. 29,543.

Direct all correspondence and telephone calls to: William H. Meise,  
Patent Operation, Lockheed Martin Corporation, Room 314B, Bldg. 28,  
P. O. Box 8048, Philadelphia, PA 19101, (610) 354-6426.

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under §1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

Full name of first inventor: Richard Allen Venable

Inventor's signature: Richard Allen Venable Date: 7-15-98

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CERTIFICATION UNDER 37 C.F.R. 1.10

I hereby certify that this New Application Transmittal and the documents referred to as being enclosed therein are being deposited with the United States Postal Service on this date \_\_\_\_\_ in an envelope as "Express Mail Post Office to Addressee", mailing label No. \_\_\_\_\_, addressed to: Assistant Commissioner for Patents, Washington, D.C. 20231 \_\_\_\_\_

William H. Meise \_\_\_\_\_ date

PLANISHING APPARATUS AND METHOD

The invention described herein was made in the performance of work under NASA Contract No. 36200 and is subject to the provisions of section 305 of the National Aeronautics and Space Act of 1958 (42 U.S.C. 2457).

This application claims priority of Provisional Patent Application Serial No. 60/083,398, filed April 29, 1998.

Field of the Invention

This invention relates to techniques for planishing or stress relieving joints, welds or the like in substantially planar structures.

Background of the Invention

When fabricating large structures such as external propellant tanks for the Space Shuttle, large sheets of aluminum alloy are curved and welded along joints to define the overall shape of the tanks. The welding is preferably performed by automatic welding machinery, such as, for example, that described

in U.S. Patent 5,483,039, issued January 9,  
1996 in the name of Gallagher. It has been  
found that stress relieving or planishing of  
the welded joint is advantageous, as described,  
5 for example, in U.S. Patent application serial  
number 08/803,481, filed February 20, 1997 in  
the name of Shah et al. As described therein,  
planishing is accomplished by use of a  
planishing hammer applied to the weld on one  
10 side of the structure, and a backing or bucking  
bar held in a corresponding location on the  
other side of the structure.

It will be appreciated that the metal  
from which the propellant tank of the Space  
15 Shuttle is fabricated may, in some locations,  
be relatively thin, for weight minimization.  
During the planishing operation, the backing  
bar must be applied to the reverse side of the  
plates being welded, to prevent damage or  
20 actual puncturing of the plates by the hammer.

As mentioned, the tanks are very large, so a  
human operator and either a backing bar or a  
power hammer can easily be accommodated within  
the tank, and the curvature of the plates is so  
25 large that, at any particular location, the  
joint or weld to be planished lies in an  
essentially planar structure.

It has been found to be difficult to  
reliably maintain the backing bar at a position  
30 on one side of the structure which corresponds  
to the location of the head of the planishing  
hammer. While the weld is visible from both

sides of the structure, the exact position  
along the weld which is being planished must be  
identified to within the diameter of the  
backing bar. Attempts have been made to use  
5 radio communications to give instructions and  
information across the welded walls, but this  
has not proven to be effective.

Improved arrangements for identifying  
the location of a planishing hammer are  
10 desired.

#### Summary of the Invention

Thus, an assemblage of parts  
according to an aspect of the invention is  
15 suited for planishing a preferably nonmagnetic,  
generally planar structure including first and  
second broad surfaces. The assemblage of parts  
comprises a planishing hammer including a body,  
a hammer head, and driving means coupled to the  
20 body and to the head, for driving the hammer  
head in a fore-and-aft direction in a  
reciprocating manner over a range of travel.  
In use, the head of the hammer is applied to or  
held against the first broad surface of the  
25 planar structure. The assemblage of parts  
includes a first magnet, and a first magnet  
support arrangement coupled to the body and to  
the first magnet, for supporting the first  
magnet at a fore-aft location, measured from  
30 the first surface adjacent the range of travel,  
which position is laterally displaced from the  
head relative to the fore-aft direction. As a

result of support of the first magnet in this manner, the magnetic field of the first magnet penetrates the planar structure when the head is adjacent the first broad surface. The  
5 assemblage of parts further includes a second magnet adapted to be located on the second broad surface of the planar structure, and to be held in place against the second broad surface of the planar structure by the magnetic  
10 field of the first magnet. A backing piece or bar of the assemblage of parts is adapted to be held against the second broad surface at the joint or weld of the planar structure, at a location identified by the location of the  
15 second magnet.

In one embodiment of the invention, the first magnet support arrangement comprises an elongated rod extending in the fore-and-aft direction; the support arrangement includes  
20 fore and aft ends. The first rod terminates at the fore end at the first magnet. The first magnet support arrangement also includes an affixing arrangement coupled to the body and the rod. The affixing arrangement is affixed  
25 to the rod at a location lying between the fore and aft ends.

A method according to an aspect of the invention is for planishing an elongated, visible joint in a nonmagnetic, generally  
30 planar structure including first and second broad surfaces. The method includes the step of procuring an assemblage of parts similar to



that described above. More particularly, the procuring step procures

(a) a planishing hammer including a body including a hammer head and driving arrangement coupled to the body and the head, for driving the hammer head in a fore-and-aft direction in a reciprocating manner over a range of travel;

(b) a first magnet;

10 (c) first magnet support arrangement coupled to the body and to the first magnet, for supporting the first magnet at a fore-aft location generally adjacent the range of travel, and laterally displaced from the head relative to the fore-aft direction;

(d) a second magnet; and

(e) a backing piece.

The method further comprising the step of, on a first side of the planar structure adjacent the first broad surface, holding the hammer with the head against the joint on the first broad surface of the planar structure, and with the first magnet at a location which is on a line orthogonal to the direction of elongation of the joint at the location of the head, whereby the magnetic field of the first magnet penetrates the planar structure to the second side thereof. The method also includes the further step of, on a second side of the planar structure adjacent the second broad surface, placing the second magnet on the second surface within the magnetic field of the first magnet,

as a result of which the second magnet is attracted toward the first magnet. The backing piece is placed on the second broad surface at a location on the elongated joint at which a line extending from the second magnet to the elongated joint joins the joint orthogonally. An important step in this method is selection of the strength of the first and second magnets in conjunction with at least one of the thickness and the material of the structure as measured between the first and second broad surfaces, in such a manner that the second magnet is held against the second broad surface of the planar structure by the magnetic field produced by the first magnet. The planishing method further includes operation of the hammer so that the head strikes the joint on the first surface of the structure.

According to another manifestation of the invention, a sensor arrangement providing an indication in one dimension of the location of a hidden magnet. The sensor comprises a set of a plurality of magnetic sensors arrayed in a straight line in an array direction. Each of the magnetic sensors is capable of responding to the strength of a magnetic field by adopting or changing an electrical characteristic. A set of a plurality, no less in number than the number of the plurality of magnetic sensors, of electrically actuated indicators is arrayed in a direction parallel to the array direction. A source of electrical energy, which may be a

battery, is provided, and a control arrangement  
is coupled to the source, to the arrayed set  
magnetic sensors and to the arrayed set of  
indicators, for providing an indication of the  
5 position along the array of magnetic sensors at  
which the magnetic field is greatest. In a  
preferred embodiment of this manifestation,  
each of the electrically actuated indicators  
comprises a solid-state light emitter, which  
10 may be a light-emitting diode or a laser. The  
preferred magnetic sensors include solid-state  
devices such as Hall-effect devices or Giant  
Magneto-Resistive sensors. In a particular  
version of this manifestation, the number of  
15 the plurality of the magnetic sensors exceeds  
two, and the control arrangement comprises an  
array of electrical conductors. The array of  
electrical conductors includes individual ones  
of the electrical conductors which are  
20 associated only with an individual one of the  
magnetic sensors and with a corresponding  
associated one of the indicators, for allowing  
the flow of current through the one of the  
magnetic sensors and the associated one of the  
25 indicators, but not through others of the  
magnetic sensors and indicators. In another  
version of this manifestation, the number of  
the plurality of the magnetic sensors in the  
sensor arrangement is two, and the control  
30 arrangement comprises a differential processing  
arrangement coupled to the source of electrical  
energy, to the magnetic sensors, and to the

indicator arrangement.

Brief Description of the Drawing

FIGURES 1a, 1b, and 1c are simplified  
5 God's-eye, plan, and front elevation views,  
respectively, of a nonmagnetic planar  
workpiece, planishing hammer, and sensor  
according to an aspect of the invention;

FIGURES 2a, 2b, and 2c are simplified  
10 God's-eye, plan, and front elevation views,  
respectively, of a planar workpiece, planishing  
hammer, and sensor according to another  
manifestation of the invention;

FIGURES 2d and 2e are simplified  
15 front and rear elevation views of a structure  
including a joint, illustrating another method  
for use of the sensor of FIGURES 2a, 2b, and  
2c;

FIGURE 2f is a simplified schematic  
20 diagram of the sensor of FIGURES 2a, 2b, and  
2c;

FIGURE 3a is a simplified diagram of  
a planishing hammer with a first magnet located  
in the hammer head, FIGURE 3b is a simplified  
25 depiction of a backing bar with a two-magnetic-  
sensor arrangement affixed thereto for sensing  
the relationship of the backing bar to the  
magnet, and FIGURE 3c is a simplified schematic  
diagram illustrating one possible way to  
30 produce an indication from the two sensors on  
the backing bar.

Description of the Invention

In FIGURE 1a and 1b, an assemblage 10 of parts includes a planishing hammer 12 with a body 14 and a hammer head 16. Hammer head 16 is driven in a reciprocating manner in a direction illustrated by arrows 19 by a motor 17 which is mechanically coupled to the body 14 and to the hammer head 16. Motor 17 is powered by a source (not illustrated). A magnet 20 is supported by an elongated support rod 22 defining a fore end 22f and an aft end 22a. Support rod 22 extends parallel to the direction 19 of reciprocating motion of the hammer head 16, and is fastened to the hammer body 14 by an attachment arrangement 18, which includes first and second attachments 18a and 18b. Attachments 18a and 18b couple to the support rod 22 at a location lying between fore end 22f and aft end 22a.

Assemblage of elements 10 further includes a second magnet 24 and a backing or bucking bar 26. As illustrated in FIGURE 1a, a nonmagnetic plate or generally planar structure 30 is seen in God's eye view, which is to say a view in which both broad sides 31 and 32 are simultaneously visible. As illustrated, planar structure 30 has a vertically oriented elongated weld 34, which defines an axis 8 of elongation. The hammer 12 is located on a first side 1 which faces first surface 31 of planar structure 30, with hammer head 16 applied to a location along the weld 34. The

second magnet 24 and backing bar 26 are located on a second side 2 of the planar structure 30.

The second side 2 faces the second surface 32 of the planar structure 30. The backing bar 26  
5 is applied to weld 34 on second surface 32 at a location corresponding to that at which hammer head 16 is applied to the first surface 31.

As mentioned above, it is difficult to determine the exact location to which the  
10 backing bar should be applied. It must be appreciated that the planar structure 30 is part of a large tank, which prevents communication around sides of the structure, which are illustrated for ease in  
15 representation. According to a first aspect of the invention, the support rod 22 is positioned so that magnet 20 is located near the forward end of the range of travel T of hammer head 16, as illustrated in FIGURE 1b. The exact axial  
20 position at which first magnet 20 should be positioned will depend, in part, on the hammer reciprocation speed. If the reciprocation speed is high, the hammer body will be held at a distance from the first surface 31 which  
25 corresponds to the maximum excursion of the hammer head, represented in FIGURE 1b by phantom head position 16<sub>2</sub>, in which case magnet support rod 22 can be positioned so that first magnet 20 lies just behind, or away from the  
30 surface 31. On the other hand, if the hammer repetition rate were very low, the hammer body would make slow excursions toward and away from

the surface 31 of structure 30, in which case the rod 22 would have to be positioned so that the first magnet 20 was slightly behind the aft-most position of the hammer, in order to avoid hitting the first surface 31. Hitting of the surface 31 by the first magnet 20 is not per se objectionable, but might chip the magnet, damage the surface, or make it difficult to control the hammer's position.

First magnet 20 is selected to be sufficiently strong to produce a magnetic field 40 which penetrates through the planar structure in the context of a nonmagnetic structure, or to produce a suitable magnetic field on the second side of the structure, and to hold the second magnet in place adjacent the first magnet. The preferred type of magnet 20 is made from Neodymium Iron Boron.

In a method according to the invention, the backing bar is located on the second side 2, and is applied to the second surface 32 of the planar structure 30 at a location selected as described in conjunction with FIGURE 1c. As illustrated in the top or plan view of FIGURE 1b, the hammer 12 is held so that the first magnet 20 is to one side of the joint 34. More particularly, the hammer is held so that first magnet 20 is at a location corresponding to location 241 of FIGURE 1c. Location 241 is the location at which second magnet 24 is held by the magnetic field of first magnet 20. As illustrated in FIGURE 1c,

location 241 lies on an imaginary line 50 which is orthogonal to the axis 8 of joint 34, as suggested by right-angle symbol 52. With this positioning of the hammer 12 and first magnet 20, the second magnet 24 gives a visual indication of the location 54 to which the backing bar 26 should be applied so as to directly behind the location to which the hammer head 16 is applied. The vibration of the structure occasioned by operation of hammer 12 provides second magnet 24 with the slight mechanical energy which is required to allow it to move to follow the changing position of hammer 12 and first magnet 20 during planishing. Thus, the second magnet 24 moves with the hammer 12, and the location to which the backing bar 26 is applied is simply the orthogonal projection from the location of the second magnet 24 to the joint 34.

FIGURES 2a, 2b, and 2c are similar to FIGURES 1a, 1b, and 1c, and corresponding elements of the FIGURES are designated by the same reference numerals. In FIGURES 2a, 2b, and 2c, the magnetic sensor, instead of being a simple magnet 24, is a sensor arrangement designated 224. As illustrated, sensor arrangement 224 is elongated, and bears an array 200 of magnetic field indicators 201, 202, 203, 204, 205, 206, 207, 208, 209, and 210. One of the indicators, namely indicator 203, is illustrated as being illuminated (or conversely, darkened) in FIGURE 2c. This



identifies the location of the strongest portion of the magnetic field generated by first magnet 20 applied to the first side 31 of structure 30. The location 254 to which the  
5 backing bar 26 should be applied is determined from the illuminated (or darkened) one of the indicators of set 200 of magnetic field or strength indicators, by orthogonally (symbol 252) projecting a line 250 from the illuminated  
10 indicator 203 to the axis 8 of elongation of the joint 34.

FIGURES 2d and 2e illustrate the relationships on sides 1 and 2, respectively, of planar structure 30, for a different  
15 orientation of the magnetic sensor arrangement 224. As illustrated in FIGURE 2e, the sensor arrangement 224 is attached to that end of the backing bar which is adjacent to the second surface 32 of the planar structure, and is held  
20 with the sensor array oriented parallel with the axis 8 of elongation of the joint 34, which is in the vertical direction in FIGURE 2e. As illustrated in FIGURE 2d, the hammer 12 is held so the magnet 20 lies directly over the joint  
25 34 being planished. The magnetic field of the magnet 20 extends through the joint, affects the array of magnetic sensors associated with sensor arrangement 224. As in the case of the embodiment of FIGURES 2a, 2b, and 2c, the  
30 sensor arrangement 224 responds by illuminating or darkening an appropriate one of the indicators, to thereby give an indication of

where the magnet is located on the first side  
1. In this case, the backing bar 26 is moved  
up or down along the joint until a particular  
one of the indicators of array 200 is  
5 illuminated or darkened; it should preferably  
be one in the center of the array, as for  
example indicator 205.

FIGURE 2f is a simplified schematic  
diagram of one embodiment of a sensor  
10 arrangement 224. In FIGURE 2f, a set 262 of  
individual Hall-effect magnetic field sensors  
262a, 262b, 262c, . . . , 262d, 262e, 262f,  
262g, 262h is line-arrayed parallel to a line  
280. The Hall sensors are energized from a  
15 source of electrical energy illustrated as a  
battery 266, by way of two conductors or buses  
268, 270. A set 264 of indicators 264a, 264b,  
264c, . . . , 264d, 264e, 264f, 264g, 264h is  
similarly arrayed parallel to line 280. An  
20 interconnection arrangement including a common  
conductor 272 and a set 274 of a plurality of  
individual conductors 274a, 274b, 274c, . . . ,  
274d, 274e, 274f, 274g, and 274h interconnects  
the individual members of the arrayed set 262  
25 of magnetic sensors with corresponding  
individual members of the set 264 of  
indicators. More particularly, conductor 274a  
interconnects sensor 262a with indicator 264a,  
conductor 274b interconnects sensor 262b with  
30 indicator 264b, conductor 274c interconnects  
sensor 262c with indicator 264c, conductor 274d  
interconnects sensor 262d with indicator 264d,

conductor 274e interconnects sensor 262e with  
indicator 264e, conductor 274f interconnects  
sensor 262f with indicator 264f, conductor 274g  
interconnects sensor 262g with indicator 264g,  
5 and conductor 274h interconnects sensor 262h  
with indicator 264h. These individual  
connections control or assure that sensing of a  
magnetic field by one of the sensors 262a,  
262b, 262c, . . . , 262d, 262e, 262f, 262g, 262h  
10 illuminates only the corresponding one of the  
indicators 264a, 264b, 264c, . . . , 264d, 264e,  
264f, 264g, 264h.

FIGURE 3a illustrates a planishing  
hammer 12 including a body 14 and a hammer head  
16. A magnet 320 is centered in hammer head  
16, so its magnetic field can be sensed. In  
FIGURE 3b, a backing bar 326 bears a sensor box  
324 which is to be held above the backing bar.

The backing bar also bears a set 300 of two  
20 Giant Magneto-Resistive (GMR) magnetic sensors  
301 and 302, located above and below the fore  
end 326f of the bar. When the backing bar 326  
is correctly positioned relative to the hammer  
head 16 of FIGURE 3a, GMR sensors 301 and 302  
25 are located above and below magnet 320 by the  
same distance, and so have the same resistance.

When one sensor 301, 302 is closer to the  
magnet 320 than the other, their resistances  
will differ.

30 FIGURE 3c is a simplified schematic  
diagram of a differential sensing arrangement  
for providing an indication of the relative

positioning of the backing bar and the hammer head/magnet. In FIGURE 3c, a battery 366 is supplies power to a Wheatstone bridge circuit 326, which includes first and second equal-  
5 value fixed resistors 328, 330 connected to the positive terminal of the battery and to the sensing terminals 340, 342, respectively, of the bridge. The GMR sensors 301, 302 are connected from the negative battery terminal  
10 (by way of ground) to sensing terminals 340, 342, respectively. A differential indicator in the form of a galvanometer 332 is coupled across the sensing terminals. Deflection of the needle of the galvanometer in one direction or the other indicates that the GMR sensors are  
15 unbalanced, and that the backing bar should be moved in the appropriate direction to equalize the magnetic fields at the GMR sensors, to thereby center the backing bar on the magnet  
20 320. For ease of interpretation, the galvanometer 332 is preferably mounted so that the deflection of the needle indicates the direction in which the backing bar should be moved.

25 Other embodiments of the invention will be apparent to those skilled in the art. For example, while Hall-effect and other solid-state sensors are described, the magnetic field sensors might be as simple as magnetically  
30 actuated reed switches. The substantially planar structure 30 may be made from aluminum alloy, such as aluminum-lithium alloy, or from

any other material which allows the magnetic field 40 of the first magnet 20 to penetrate to the second side 2 with sufficient strength to hold the second magnet 24 in place; this might  
5 even be a thin sheet of "soft" steel, which would allow sufficient magnetization of the material to occur so as to produce a suitable magnetic field on the second side 32 of the structure. While the number of magnetic field  
10 indicators associated with sensor arrangement 224 has been described as ten, this number is arbitrary, and could be greater or less. While a simple galvanometer circuit has been  
15 illustrated for providing a differential indication from the two-sensor version of FIGURES 3a and 3b, those skilled in the art know that many circuit configurations may be used, including electronic processing devices, and similarly that a multiple-indicator array  
20 may be used with a two-sensor indicator, if desired.

Thus, an assemblage of parts (10) according to an aspect of the invention is suited for planishing a preferably nonmagnetic,  
25 generally planar structure (30) including first (31) and second (32) broad surfaces. The assemblage of parts (10) comprises a planishing hammer (12) including a body (14), a hammer head (16), and driving means (17) coupled to  
30 the body (14) and to the head (16), for driving the hammer head (16) in a fore-and-aft direction (19) in a reciprocating manner over a

range of travel (T). In use, the head (16) of the hammer (12) is applied to or held against the first broad surface (31) of the planar structure (30). The assemblage of parts  
5 includes a first magnet (20), and a first magnet support arrangement (18, 22) coupled to the body (14) and to the first magnet (20), for supporting the first magnet (20) at a fore-aft location (d, measured from the first surface  
10 31) adjacent the range (T) of travel, which position is laterally displaced from the head relative to the fore-aft direction (19). As a result of support of the first magnet (20) in this manner, the magnetic field (40) of the  
15 first magnet (20) penetrates the planar structure (30) when the head (16) is adjacent the first broad surface (31). The assemblage of parts (10) further includes a second magnet (24) adapted to be located on the second broad  
20 surface (32) of the planar structure (30), and to be held in place against the second broad surface (32) of the planar structure (30) by the magnetic field (40) of the first magnet (20). A backing piece or bar (26) of the  
25 assemblage of parts (10) is adapted to be held against the second broad surface (32) at the joint or weld (34) of the planar structure (30), at a location identified by the location of the second magnet (24).

30 In one embodiment of the invention, the first magnet (20) support arrangement (18, 22) comprises an elongated rod (22) extending

in the fore-and-aft direction (19); the support arrangement includes fore (20f) and aft (20a) ends. The first rod (20) terminates at the fore end (20f) at the first magnet (20). The  
5 first magnet support arrangement also includes an affixing arrangement (18) coupled to the body (14) and the rod (20). The affixing arrangement (18) is affixed to the rod (20) at a location lying between the fore (20f) and aft  
10 (20a) ends.

A method according to an aspect of the invention is for planishing an elongated, visible joint (34) in a nonmagnetic, generally planar structure (30) including first (31) and  
15 second (32) broad surfaces. The method includes the step of procuring an assemblage of parts similar to that described above. More particularly, the procuring step procures

(a) a planishing hammer (12) including a body (14) including a hammer head (16) and driving arrangement (17) coupled to the body (14) and the head (16), for driving the hammer head (16) in a fore-and-aft  
20 direction (19) in a reciprocating manner over a range of travel (T);

(b) a first magnet (20);  
(c) first magnet (20) support arrangement (18, 22) coupled to the body (14) and to the first magnet (20), for supporting  
30 the first magnet (20) at a fore-aft location (d) generally adjacent the range of travel, and laterally displaced from the head relative to

the fore-aft direction (19);

(d) a second magnet (24); and

(e) a backing piece (26).

The method further comprising the step of, on a  
5 first side (1) of the planar structure (30)  
adjacent the first broad surface (31), holding  
the hammer (12) with the head (16) against the  
joint (34) on the first broad surface (31) of  
the planar structure (30), and with the first  
10 magnet (20) at a location (241) which is on a  
line (50) orthogonal (52) to the direction of  
elongation (8) of the joint (34) at the  
location of the head (16), whereby the magnetic  
field (40) of the first magnet (20) penetrates  
15 the planar structure (30) to the second side  
(2) thereof. The method also includes the  
further step of, on a second side (2) of the  
planar structure (30) adjacent the second broad  
surface (32), placing the second magnet (24) on  
20 the second surface (32) within the magnetic  
field (40) of the first magnet (20), as a  
result of which the second magnet (24) is  
attracted toward the first magnet (20). The  
backing piece (26) is placed on the second  
25 broad surface (32) at a location (54) on the  
elongated joint (34) at which a line (50)  
extending from the second magnet (24) to the  
elongated joint (34) joins the joint (34)  
orthogonally (52). An important step in this  
30 method is selection of the strength of the  
first and second magnets (24) in conjunction  
with at least one of the thickness (t) and the



material of the structure (30) as measured  
between the first (31) and second (32) broad  
surfaces, in such a manner that the second  
magnet (24) is held against the second broad  
5 surface (32) of the planar structure (30) by  
the magnetic field (40) produced by the first  
magnet (20). The planishing method further  
includes operation of the hammer (12) so that  
the head (16) strikes the joint (34) on the  
10 first surface (31) of the structure (30).

According to another manifestation of  
the invention, a sensor arrangement (224)  
providing an indication in one dimension of the  
location of a hidden magnet. The sensor (224)  
15 comprises a set (262) of a plurality (eight  
illustrated in FIGURE 2f) of magnetic sensors  
(262a, 262b, 262c, 262d, 262e, 262f, 262h)  
arrayed in a straight line (280) in an array  
direction (280). Each of the magnetic sensors  
20 (262a, 262b, 262c, 262d, 262e, 262f, 262h) is  
capable of responding to the strength of a  
magnetic field (40) by adopting or changing an  
electrical characteristic. A set (264) of a  
plurality (eight illustrated in FIGURE 2e), no  
25 less in number than the number (eight) of the  
plurality of magnetic sensors (262a, 262b,  
262c, 262d, 262e, 262f, 262h), of electrically  
actuated indicators (264a, 264b, 264c, 264d,  
264e, 264f, 264h) is arrayed in a direction  
30 parallel to the array direction (280). A  
source (266) of electrical energy, which may be  
a battery, is provided, and a control

arrangement (268, 270, 272, 274) is coupled to the source, to the arrayed set (262) magnetic sensors (262a, 262b, 262c, 262d, 262e, 262f, 262h) and to the arrayed set (264) of indicators (264a, 264b, 264c, 264d, 264e, 264f, 264h), for providing an indication of the position along the array (262) of magnetic sensors (262a, 262b, 262c, 262d, 262e, 262f, 262h) at which the magnetic field (40) is greatest. In a preferred embodiment of this manifestation, each of the electrically actuated indicators (264a, 264b, 264c, 264d, 264e, 264f, 264h) comprises a solid-state light emitter, which may be a light-emitting diode or a laser. The preferred magnetic sensors (262a, 262b, 262c, 262d, 262e, 262f, 262h) include solid-state devices such as Hall-effect devices or Giant Magneto-Resistive sensors (262). In a particular version (FIGURE 2e) of this manifestation, the number (eight illustrated in FIGURE 2e) of the plurality of the magnetic sensors (262a, 262b, 262c, 262d, 262e, 262f, 262h) exceeds two, and the control arrangement (268, 270, 272, 274) comprises an array of electrical conductors. The array of electrical conductors includes individual ones (274a, 274b, 274c, 274d, 274e, 274f, 274g, 274h) of the electrical conductors which are associated only with an individual one (262a, 262b, 262c, 262d, 262e, 262f, 262h, respectively) of the magnetic sensors and with a corresponding associated one of the

indicators (264a, 264b, 264c, 264d, 264e, 264f,  
264h, respectively), for allowing the flow of  
current through the one of the magnetic sensors  
(262a, 262b, 262c, 262d, 262e, 262f, 262h) and  
5 the associated one of the indicators (264a,  
264b, 264c, 264d, 264e, 264f, 264h), but not  
through others of the magnetic sensors (262a,  
262b, 262c, 262d, 262e, 262f, 262h) and  
indicators (264a, 264b, 264c, 264d, 264e, 264f,  
10 264h). In another version of this  
manifestation, the number of the plurality of  
the magnetic sensors (301, 302) in the sensor  
arrangement is two, and the control arrangement  
comprises a differential processing arrangement  
15 (326) coupled to the source (366) of electrical  
energy, to the magnetic sensors (301, 302), and  
to the indicator arrangement (332).

WHAT IS CLAIMED IS:

1. An assemblage of parts suited for planishing a joint in a generally planar structure including first and second broad surfaces, said assemblage of parts comprising:
  - 5 a planishing hammer including a body, a hammer head, and driving means coupled to said body and to said head, for driving said hammer head in a fore-and-aft direction in a reciprocating manner over a range of travel
  - 10 against said first broad surface of said planar structure;
    - a first magnet;
    - first magnet support means coupled to said body and to said first magnet, for
    - 15 supporting said first magnet at a fore-aft location adjacent said range of travel, which position is laterally displaced from said head relative to said fore-aft direction, whereby the magnetic field of said first magnet
    - 20 penetrates said planar structure when said head is adjacent said first broad surface;
    - a second magnet adapted to be located on said second broad surface of said planar structure, and to be held in place against said
    - 25 second broad surface of said planar structure by said magnetic field of said first magnet; and
    - a backing piece adapted to be held against said second broad surface at said joint
    - 30 of said planar structure, at a location identified by the location of said second

magnet.

2. An assemblage of parts in  
accordance with claim 1, wherein said first  
magnet support means comprises an elongated rod  
extending in said fore-and-aft direction, and  
5 including fore and aft ends, said first rod  
terminating at said fore end at said first  
magnet;

affixing means coupled to said body  
and said rod, said affixing means being affixed  
10 to said rod at a location lying between said  
fore and aft ends.

3. An assemblage according to claim  
1, wherein said backing piece is a backing bar.

4. An assemblage according to claim  
1, wherein said planar structure is such that a  
magnetic field applied to a first side produces  
a magnetic field on a second side thereof.

5. A method for planishing an  
elongated, visible joint in a generally planar  
structure including first and second broad  
surfaces, said method comprising the steps of:  
5 procuring a kit of parts including  
(a) a planishing hammer including a  
body including a hammer head and driving means  
coupled to said body and said head, for driving  
said hammer head in a fore-and-aft direction in  
10 a reciprocating manner over a range of travel;

(b) a first magnet;

(c) first magnet support means  
coupled to said body and to said first magnet,  
for supporting said first magnet at a fore-aft  
15 location generally adjacent said range of  
travel, and laterally displaced from said head  
relative to said fore-aft direction;

(d) a second magnet; and

(e) a backing piece;  
20 said method further comprising the steps of  
on a first side of said planar  
structure adjacent said first broad surface,  
holding said hammer with said head against said  
joint on said first broad surface of said  
25 planar structure, with said first magnet at a  
location which is on a line orthogonal to the  
direction of elongation of said joint at the  
location of said head, whereby the magnetic  
field of said first magnet penetrates said  
30 planar structure to said second side thereof;  
on a second side of said planar  
structure adjacent said second broad surface,  
placing said second magnet on said second  
surface within said magnetic field of said  
35 first magnet, whereby said second magnet is  
attracted toward said first magnet;

placing said backing piece on said  
second broad surface at a location on said  
elongated joint at which a line extending from  
40 said second magnet to said elongated joint  
joins said joint orthogonally.

6. A method according to claim 5,  
wherein said method further comprises, in said  
procuring step, the further step of:

5 selecting the strength of said first  
and second magnet in conjunction with at least  
the thickness of said structure as measured  
between said first and second broad surfaces,  
in such a manner that said second magnet is  
held against said second broad surface of said  
10 planar structure by said magnetic field of said  
first magnet.

7. A method according to claim 5,  
wherein said method further comprises the step  
of operating said hammer so that said head  
strikes said joint on said first surface of  
5 said structure.

8. A sensor arrangement for  
providing an indication in one dimension of the  
location of a hidden magnet, said sensor  
comprising:

5 a set of a plurality of magnetic  
sensors arrayed in a straight line in an array  
direction to form an array of magnetic sensors,  
each of which magnetic sensors is capable of  
responding to the strength of a magnetic field  
10 by adopting a particular value of an electrical  
characteristic;

an indicator arrangement;  
a source of electrical energy; and  
control means coupled to said

15 magnetic sensors and to said indicator arrangement, for providing an indication of the position at which said magnetic field is greatest.

9. A sensor arrangement according to claim 8, wherein said source of electrical energy includes a battery.

10. A sensor arrangement according to claim 8, wherein said indicator arrangement comprises

5 a set including a plurality, no less in number than the number of said plurality of magnetic sensors, of electrically actuated indicators, said plurality of electrically actuated indicators being arrayed in a direction parallel to said array direction to  
10 form an array of indicators, whereby said electrically actuated indicators provides an indication of the location along said array of magnetic sensors at which the magnetic field is greatest.

11. A sensor arrangement according to claim 10, wherein each of said electrically actuated indicators comprises a solid-state light emitter.

12. A sensor arrangement according to claim 11, wherein each said solid-state light emitters comprises a light-emitting



diode.

13. A sensor arrangement according to claim 11, wherein said solid-state light emitters comprises a laser.

14. A sensor arrangement according to claim 8, wherein each of said magnetic sensors includes a Hall-effect device.

15. A sensor arrangement according to claim 8, wherein said magnetic sensors include Giant Magneto-Resistive sensor.

16. A sensor arrangement according to claim 8, wherein:

the number of said plurality of said magnetic sensors in said set of magnetic sensors exceeds two; and

5 said control means comprises an array of electrical conductors, said array of electrical conductors including individual ones of said electrical conductors which are  
10 associated only with an individual one of said magnetic sensors and with a corresponding associated one of said indicators, for allowing the flow of current through said one of said magnetic sensors and said associated one of  
15 said indicators, but not through others of said magnetic sensors and indicators.

17. A sensor arrangement according

to claim 8, wherein:

the number of said plurality of said  
magnetic sensors in said set of magnetic  
5 sensors is two; and

said control means comprises  
processing means coupled to said source of  
electrical energy, to said magnetic sensors,  
and to said indicator arrangement, for  
10 generating a signal indicative of the direction  
in which said backing bar should be moved.

Abstract of the Disclosure

Planishing or stress relief in a welded joint (34) is accomplished with a hammer (12) and a backing bar (26). The hammer is applied on a first side (1) to a first surface (31) of the structure (30). To indicate the proper position of the backing bar, a first magnet (20; 320) is associated with the hammer, and a magnetic sensor arrangement (24; 224; 300) is located on the other side (2) of the structure. In one embodiment, the sensor arrangement is a second magnet (24) which is held in place by the magnetic field (40) of the first magnet. In a second embodiment, the sensor includes a line array (262) of individual sensors, each associated with an indicator of a line array (264) of indicators. In a third embodiment, the sensor includes a line array (300) of two magnetic sensors, which are coupled to a differential indicator (324).

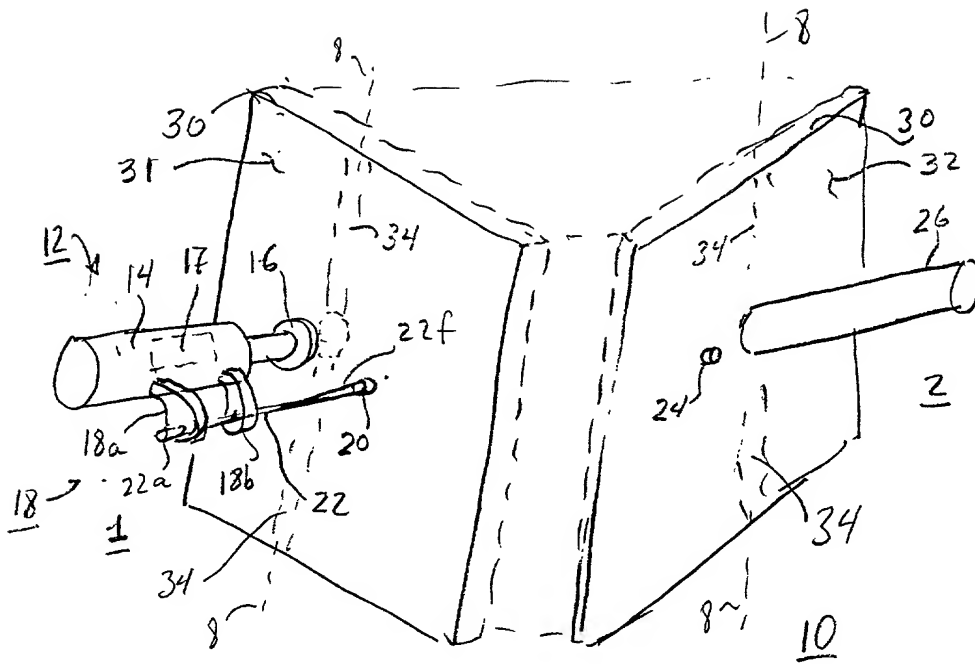


Fig. 1a

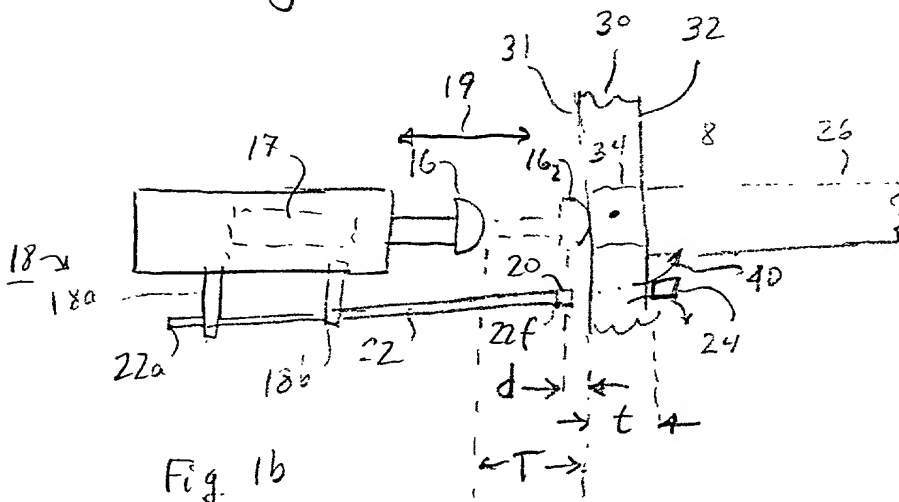


Fig. 1b

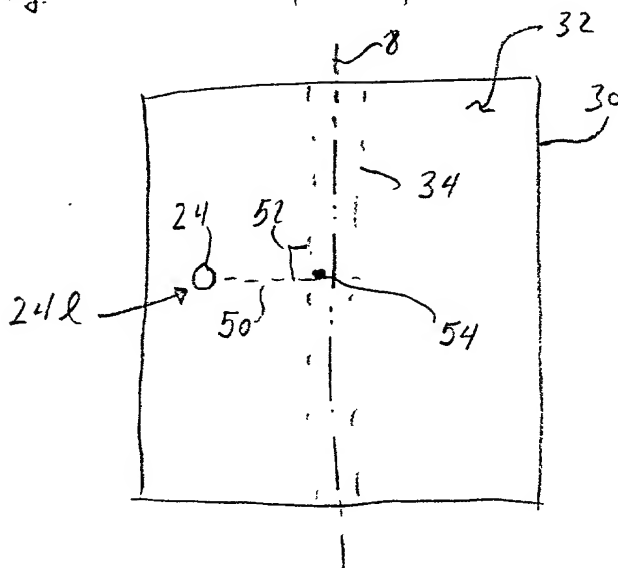
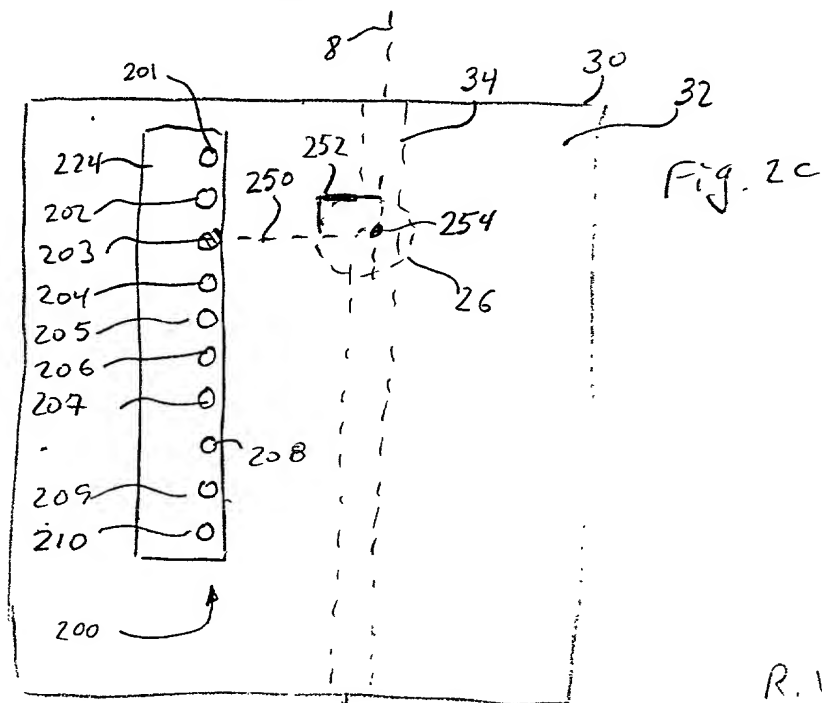
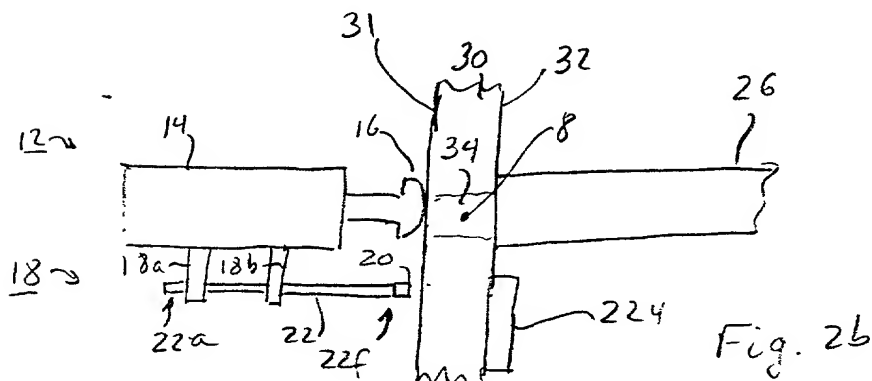
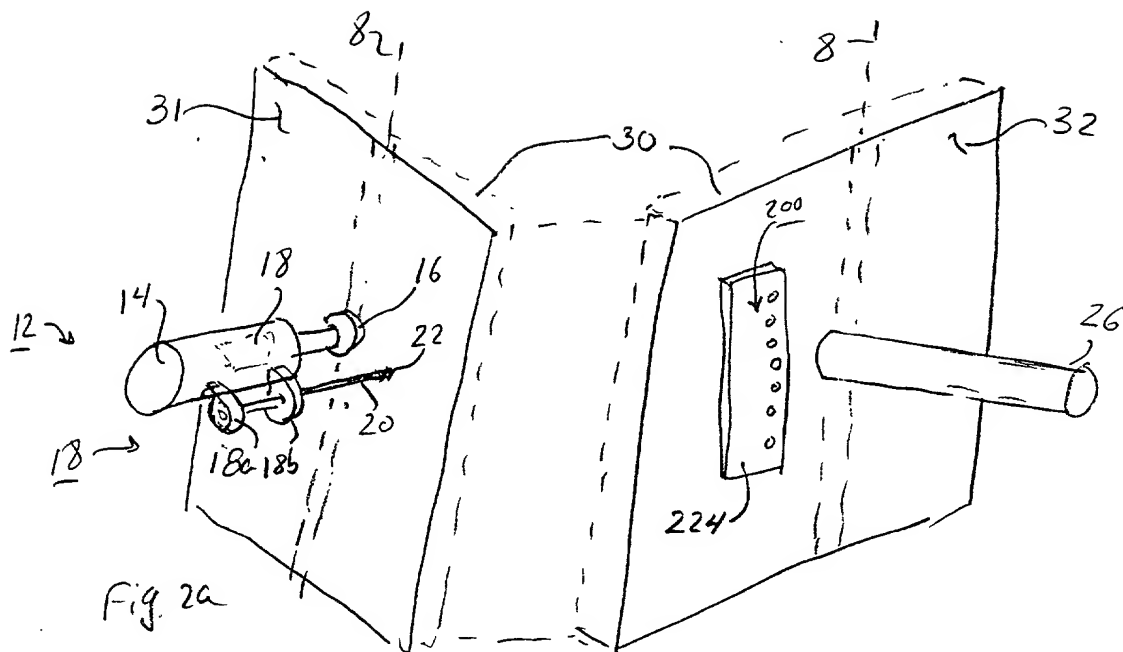


Fig. 1c

ZW-24A  
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ZW-24A  
R. Venable et al  
Sheet 2 of 5

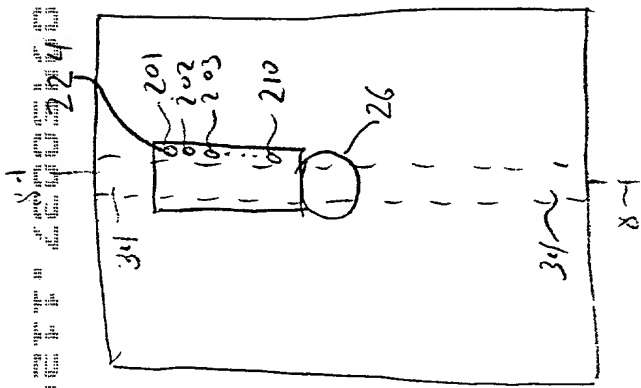


Fig. 2c

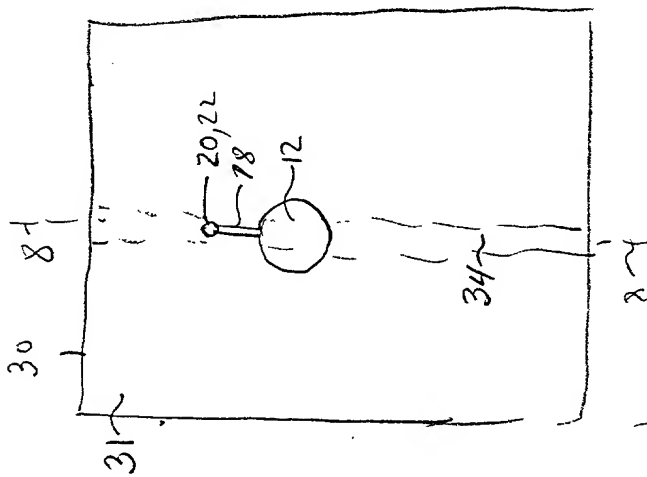


Fig. 2d

ZW-24A  
 12. Variable clal  
 Sheet 3 of 5

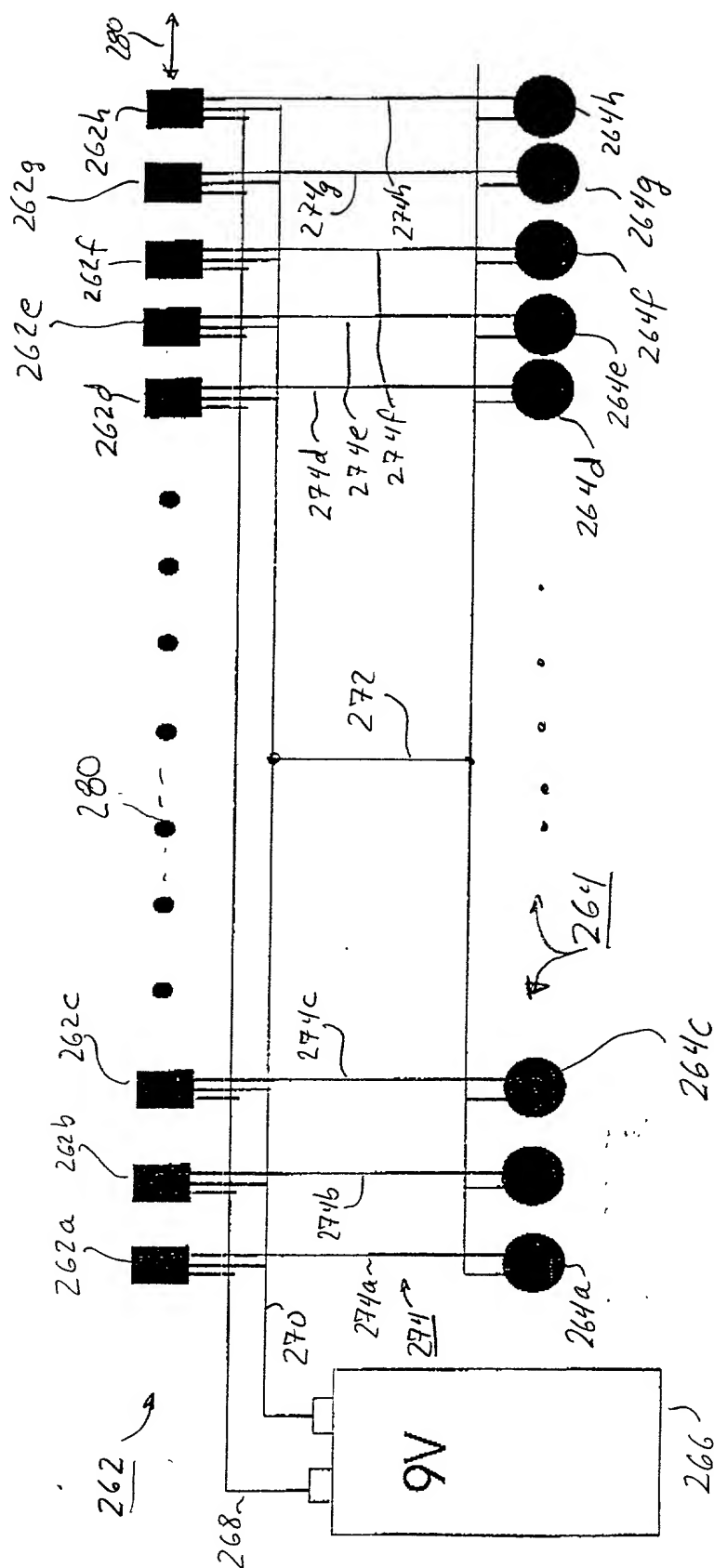


Fig. 2f

ZW-24A  
R. Venable et al  
Sheet 4 of 5

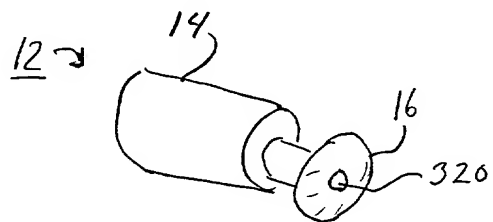


Fig. 3a

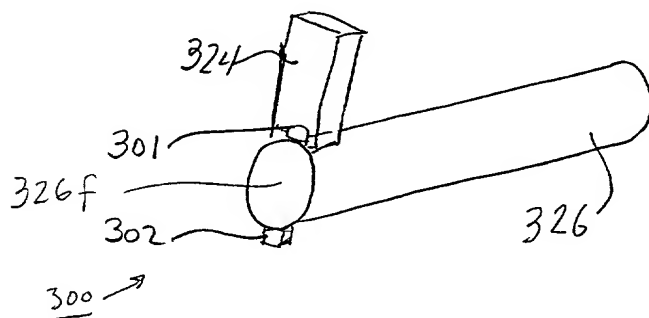


Fig. 3b

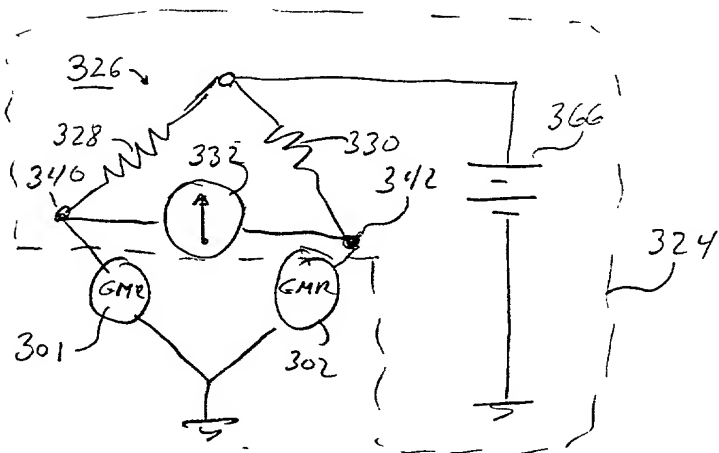


Fig. 3